

Date: Wednesday, 1/9/2008 3:42:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LITTER TIE DOWN ASS'Y
Job Number : 36696	
Estimate Number : 10360	
P.O. Number :	Part Number : D2350
This Issue : 1/9/2008 S.O. No. :	Drawing Number : D2350 / D2363
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED PARTS	Drawing Revision : B / E
Previous Run : 33777	Material :
Written By : <u>08 01 09</u>	Due Date : 1/31/2008 Qty: 6 Um: Each
Checked & Approved By : <u>08 01 09</u>	
Comment : est rev B 06.05.17 added ass'y EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D6201	T Extrusion 4X4X3/8
-----	-------	---------------------



Comment: Qty.: 1.0631 f(s)/Unit Total : -6.3788 f(s)

Material: D6201 (6061-T6 (QQ-A-200/8) 4" x 4" x 3/8" Thick 'T' extrusion

Batch: B35952X4

B29367X1

ml 08/02/03

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW

Cut blanks: 12.150" long

ml 08/02/03

⑥

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio D2363 and Dwg D2363

J.L 08/02/09

⑥

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 08/02/09

⑥

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 08/02/09

6.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

Tumble & deburr

J.L 08/02/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:42:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 36696

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Handwritten: 08-02-11 (6)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Handwritten: BR 08-02-12 (6)

9.0

POWDER COATING

POWDER COATING



Handwritten: M107005



Handwritten: (6X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Handwritten: M-1 08/02/12

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Handwritten: 08-02-12

Handwritten: (X6)

11.0

D2372

Quick Release



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2372 Fastener *Handwritten:* B37448

Handwritten: MF

12.0

D2444

Pip Pin Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2444 Pip Pin *Handwritten:* B3070

Handwritten: MF

13.0

AN960JD10L

Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

3 AN960JD10L Washer *Handwritten:* M104885

Handwritten: MF 08-03-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 1D Date: 08/03/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/9/2008 3:42:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LITTER TIE DOWN ASS'Y

Job Number: 36696

Part Number: D2350

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

MS21042L3

Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 MS21042L3 Nut (or -3) m106242

mf

15.0

MS27039113

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-1-13 Screw m13719

mf

08-03-05

16.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2350

mf

08-03-03 (6)

17.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0062105 (6)

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 185

8/3/5

sc

(6X)

19.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/03/06 (6)

Job Completion



m 2008/3/05

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED <i>[Signature]</i>	DRAWING NO. D2350	REV. B SHEET 1 OF 2
DATE 95:02:20		TITLE LITTER TIE DOWN ASSEMBLY	

RELEASED
960607

D2350	Part No.	Description
X	D2350	LITTER TIE DOWN ASSEMBLY (NON-LOCKING)
1	D2363	LITTER TIE DOWN (NON-LOCKING)
2	D2372	QUICK RELEASE FASTENER
1	D2444	PIP PIN
<i>KE</i> 3	AD960JD10 L	WASHER
1	MS21042L3	NUT
1	MS27039-A-13	SCREW

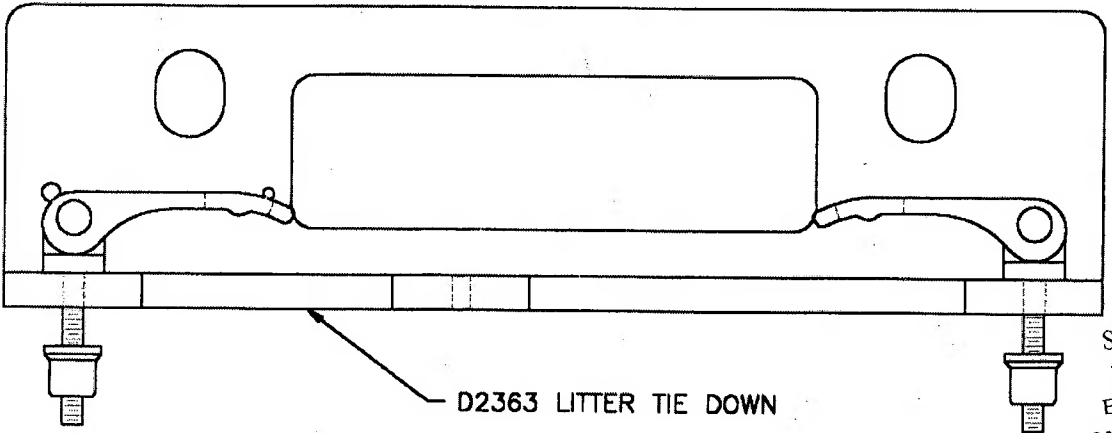
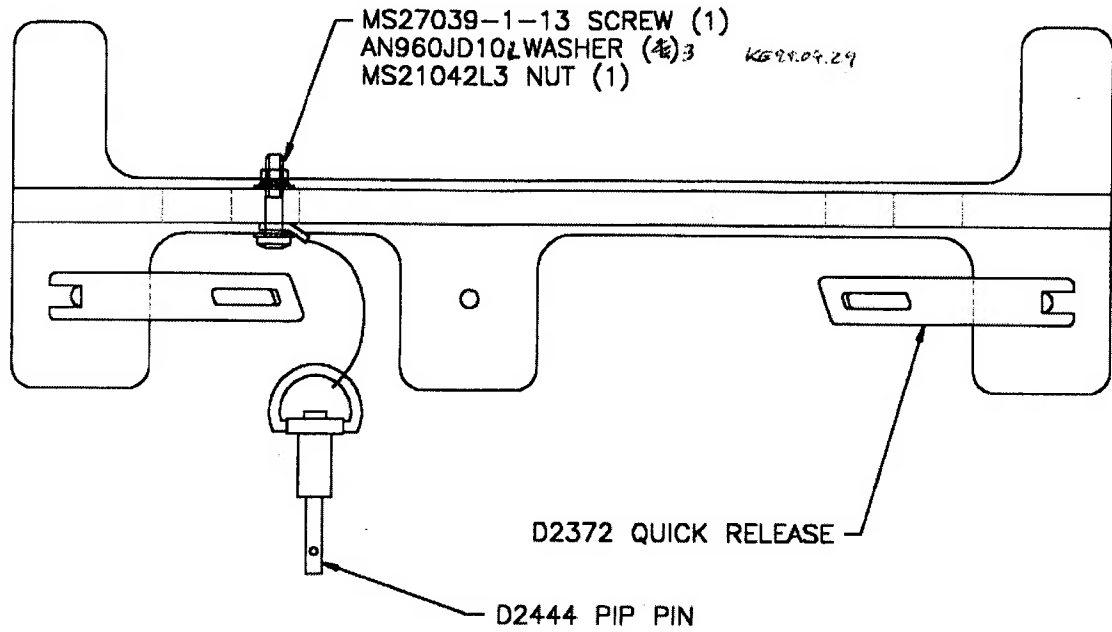
KE 99.04.29

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36696



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED	APPROVED	D2350	SHEET 2 OF 2
DATE		TITLE	SCALE
95:02:20		LITTER TIE DOWN ASSEMBLY	

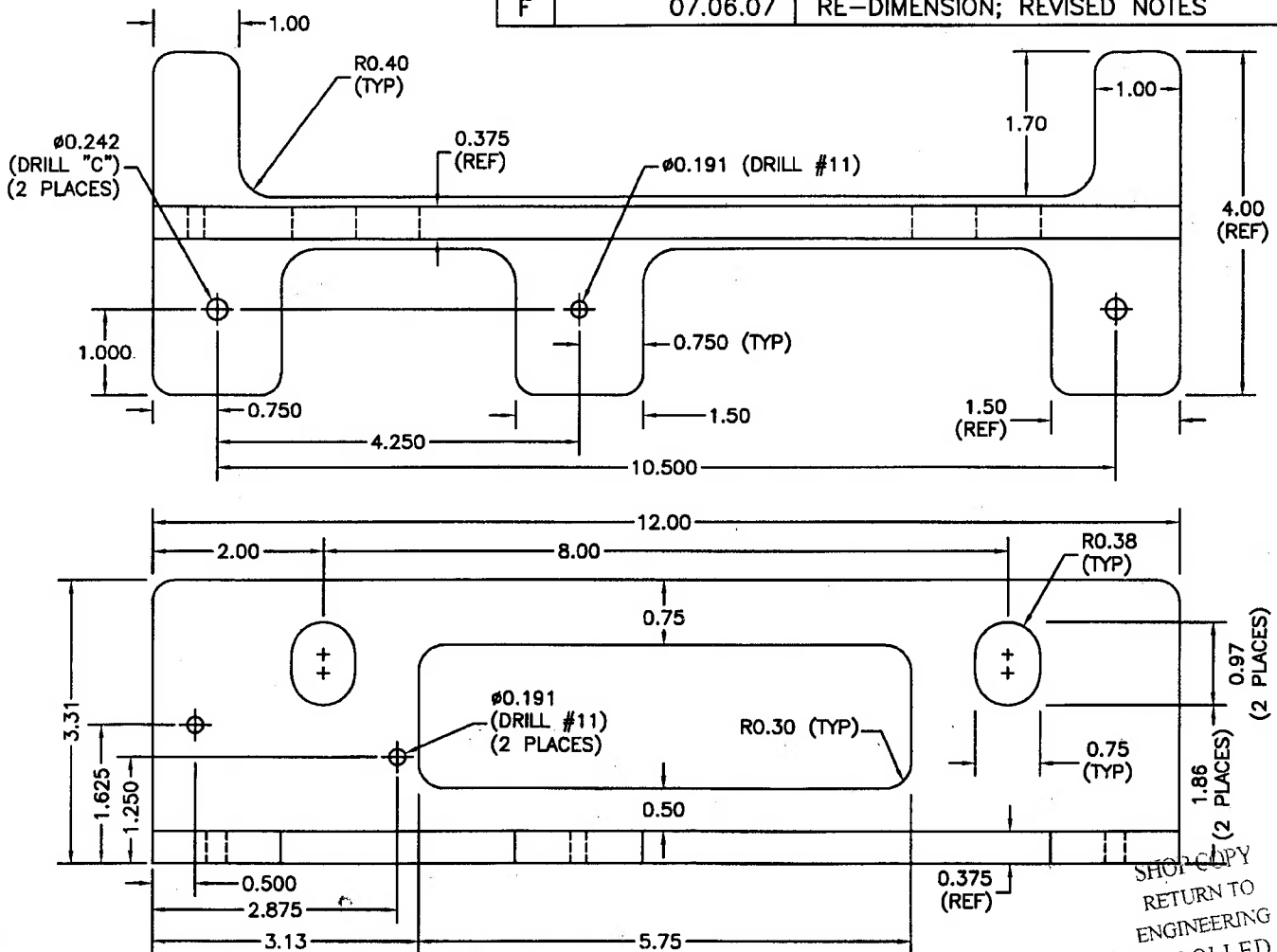
RELEASED
960607



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36696

DART

DESIGN BW	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JB	APPROVED H	DRAWING NO. D2363	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER TIE DOWN BRACKET		SCALE 1:2
A	95.01.14	NEW ISSUE	
B	95.02.14	MODIFIED HOLES	
C	95.03.06	0.191 WAS 0.197	
D	95.03.06	CHANGES TO DIMENSIONS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	RE-DIMENSION; REVISED NOTES	

**D2363 LITTER TIE DOWN BRACKET**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2363" USING FINE POINT PERMANENT INK MARKER

RELEASED

07.06.22



SHO COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36696

Copyright © 1995 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.